

Date: Friday, 17/04/2009 10:07:02 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	350 BASKET LID (SHORT)
<b>Job Number</b> :	47269B		
<b>Estimate Number</b> :	10210		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3266041
<b>This Issue</b> :	17/04/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3266 REVB
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	46309B	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	27/04/2009
<b>Written By</b> :		<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b> :	<u>JULIO 09.04.17</u>		
<b>Comment</b> :	Est Rev:B Re-Format 05-11-03 JLM Est Rev:C 08-09-10 revB as per dwg (ecn 08-524) DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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✓ 1.0	D31663	Basket Hoop
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty 1 D3166-3 Basket Hoop Batch: B46629 SAD 09-04-22

①

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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**Comment:** Qty.: 28.3500 f(s)/Unit Total : 28.3500 f(s)

3/4" x 3/4" square tubing 304/316 SS tube .065" wall

(M304TS0.750W.065)

Batch: 73342099 M111331 (26.35)

SAD 09-04-22

①

3.0	D22321	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2232-1	Hinge plate	B46709

PD 09-04-23

4.0	D23271	Spacer Bushing
-----	--------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2327-1	Bushing	B46325

PD 09-04-23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 17/04/2009 10:07:02 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET LID (SHORT)

Job Number: 47269B

Part Number: D3266041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2506	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

B44275

PD 09-04-27

6.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B46086

PD 09-04-23

7.0	M304EX07516F	Expanded Metal Flat SS
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Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

10sf M304EX0.75-16F

Expanded Metal

M111444 (8.000)

M11173 (2.000)

SAD 09-04-22

①

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236 From D3166-3

SAD

09-04-22

①

2-Cut 3/4" x 3/4" square tubing as per Dwg D3266

SAD

09-04-22

①

3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

SAD

09-04-22

①

4-Deburr & Remove all markings from material

SAD

09-04-22

①

5-Weld as per Dwg D3266 using Welding Table and corner Jig Deburr as required

PD 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Cpl 09.04.27*

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*S 09.04.27 @*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m 110939*  
*Pressure Wash MD/*

*09/04/28*

1ST COAT:

START TIME:

*13:35*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*14:05*

2ND COAT:

START TIME:

*14:20*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*14:50*

*MD/BK*

*09/04/28*

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Batch: *m 11013*

and Spray Paint black Batch: *m 110207*

as per Dwg D3266 and QSI 005 4.4

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*FL 09/04/30*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

*09.05.04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 47269B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/06 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-06

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	PART NUMBER	DESCRIPTION
X	D3266-041	BASKET ASSEMBLY
2	D2232-1	HINGE PLATE
4	D2236	RIB
2	D2327-1	BUSHING
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3266-1	RIB
2	D3266-3	RIB
6	D3266-5	RIB
3	D3266-7	RIB

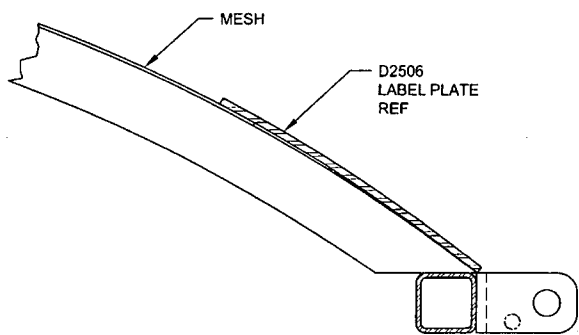
**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

**RELEASED**  
08-29-04/HP

B	INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK.	AJS	08.08.15
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	FE	D3266	SHEET 1 OF 5
APPROVED	FE	TITLE	SCALE
DE APPR.	FE	BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

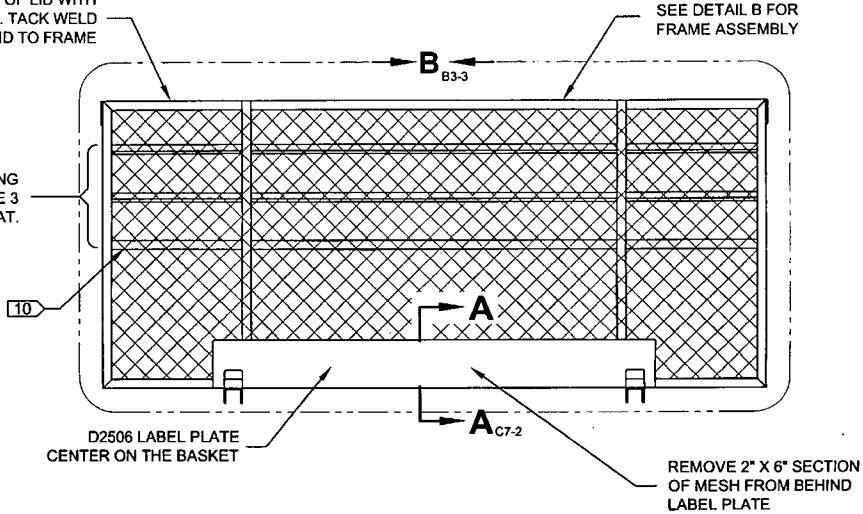
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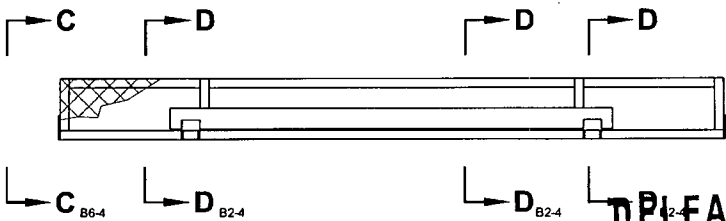
**SECTION A-A**  
(ROTATED 90° CCW)  
SCALE NONE

SKIN OUTSIDE SURFACE OF LID WITH  
SS MESH. TACK WELD  
EACH END STRAND TO FRAME

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.



**D3266-041 BASKET LID ASSEMBLY**



**RELEASED**  
08-09-24/18

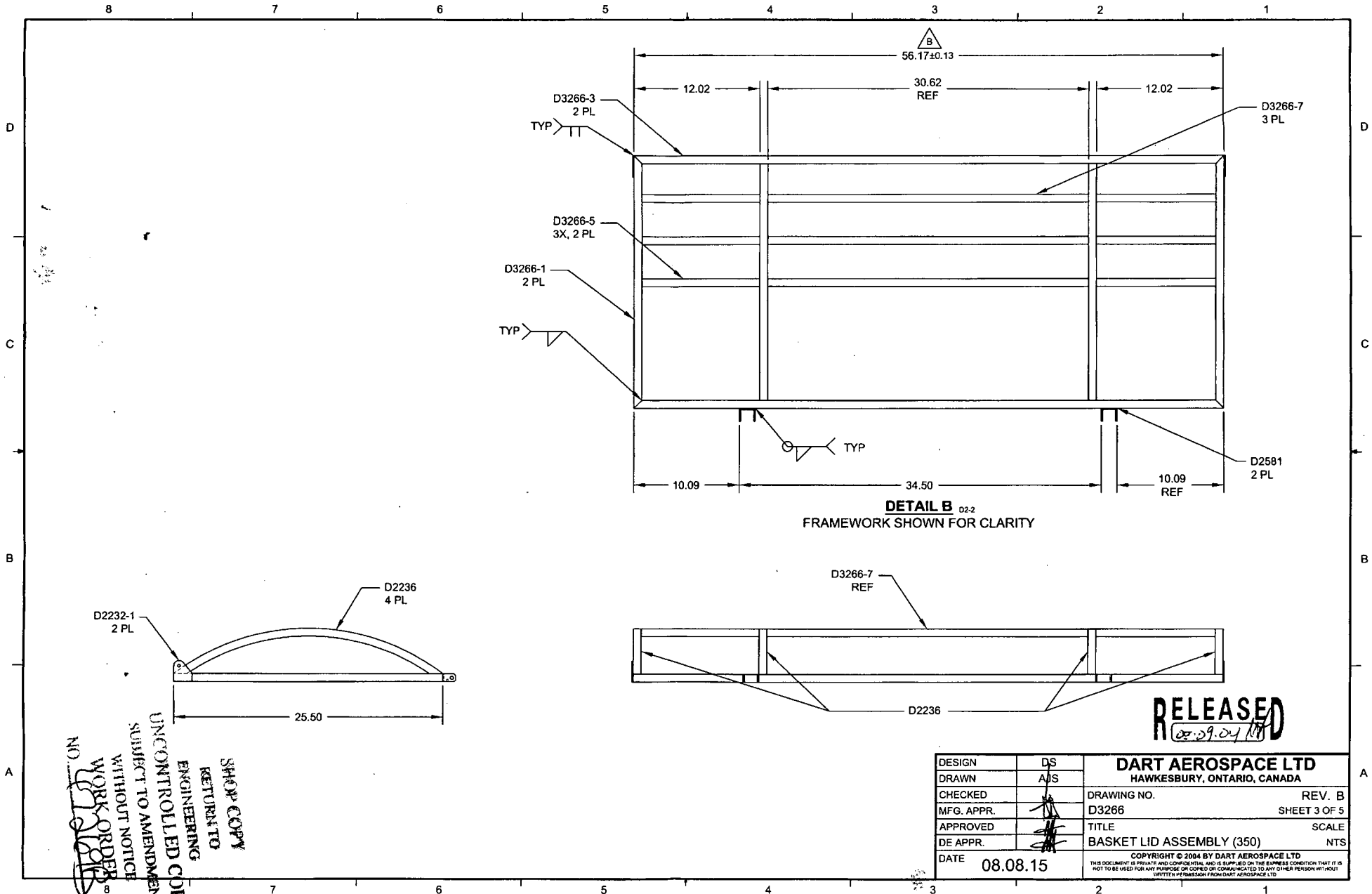
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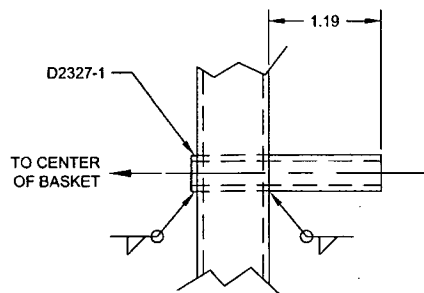
**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: FOR OVERALL FINISH SEE SHEET 1
- 3) FINISH: SPRAY PAINT BLACK INSIDE SURFACE AFTER POWDER COAT  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE  
PER DART QSI 005 4.4 AFTER POWDER COAT
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004
- 10) TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION

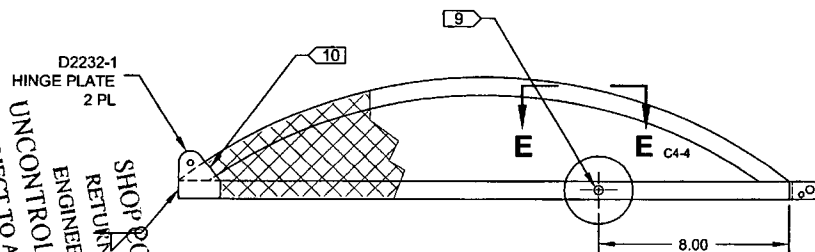
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MFG. APPR.		D3266	SHEET 2 OF 5
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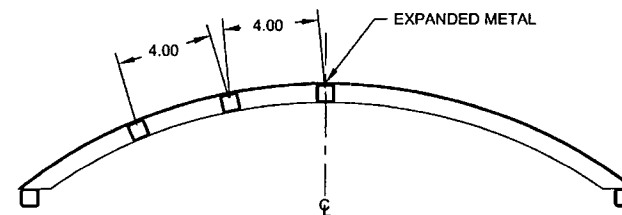




**VIEW E-E** B4-4  
SCALE 4X  
(BOTH ENDS)



**SECTION C-C** A4-2  
(BOTH ENDS)



**SECTION D-D** A1-2  
3 PL A2-2  
A3-2

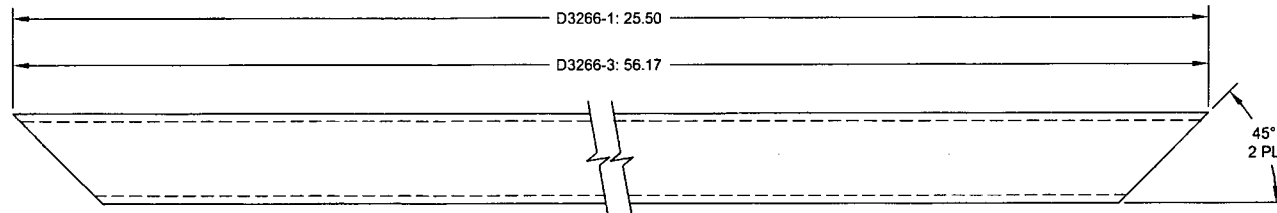
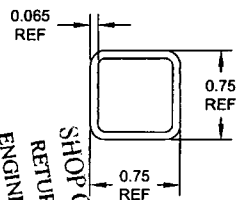
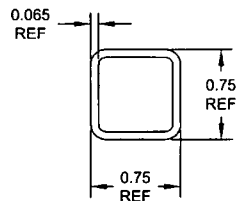
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WORK ORDER  
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WITHOUT NOTICE

**NOTES:**

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-1 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS
- 10) TRIM MESH AS REQUIRED TO ALLOW D2232-1 HINGE PLATE TO SIT FLUSH ON FRAME

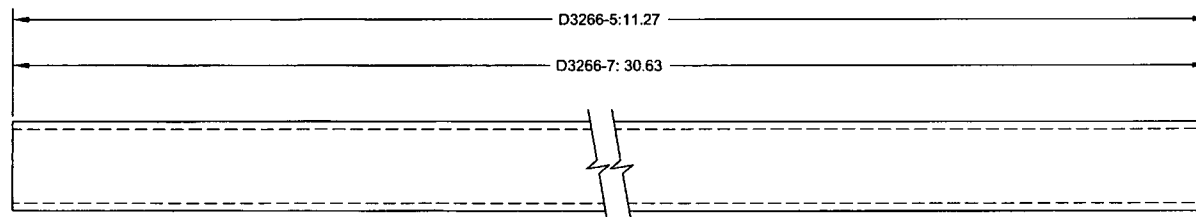
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RL	DRAWING NO.	REV. B
MFG. APPR.	RL	D3266	SHEET 4 OF 5
APPROVED	RL	TITLE	SCALE
DE APPR.	RL	BASKET LID ASSEMBLY (350)	NTS
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**D3266-1 RIB**

**D3266-3 RIB**



**D3266-5 RIB**

**D3266-7 RIB**

**RELEASED**  
08-09-01-117

- RIB NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	AS	D3266	SHEET 5 OF 5
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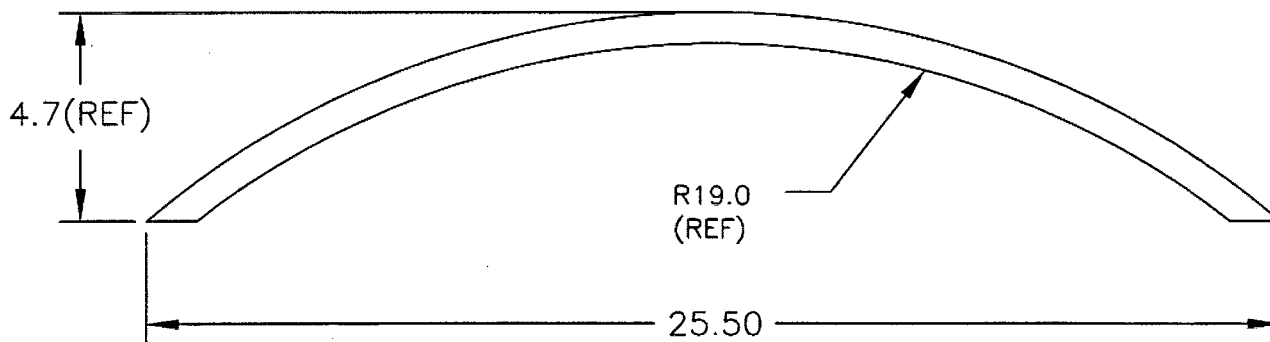
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**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2236	REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB	SCALE 1:4
A	94.05.30	NEW ISSUE	
B	94.12.16	LID	
C	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19.0	

**RELEASED**

05-08-19 #

**D2236 LID RIB**

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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